



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.2511

Job Sheet 197604



Part No: 647.2511

Job Qty: 16 pcs

Part Name: Nut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/30/19

Type: Stock

Description:

Note: DWG 647.2500 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD IPP REV:B 19.02.27 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
100	Doosan - 1	16 pcs	8/30/19	8/30/19	1.00 7.62	Doosan - 1	
110	QC 2	16 pcs	8/30/19	8/30/19	0.00 0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S208448



Part: 647.2511

Job No: 197604

Serial No/Batch: S208448

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/23/19

140 QC 8	16 pcs	8/30/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	2nd 19/08/25
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Outsource - 17 - Passivate	16 pcs	8/30/19		GRO002-VC	7 2019-08-26
160 Packaging 2-1 - Receive - B4B	16 pcs 26 AL	8/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	AL SEP 03 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	

170 QC 5	16 pcs	8/30/19	0.00 0.00	Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
180 Packaging 3-1 - Stock - B4B	16 pcs	8/30/19	0.00 0.00	QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS
				QC 5 - 40	61
				QC 5 - 61	9-89
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	68-6
				Packaging 3 - 5 - B4B	74
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	16 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21	MAC
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9.00

SEP 09 2019

Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB144 AND DWG DWG Rev: _____ FOLIO Rev: _____ -Deburr per dwg
 Descriptions: ***CHECK THREADS USING GO/ NO GO GAUGE*****

110 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check) 100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT

150 - Issue P/O: 44341 Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required

160 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certificate of conformity is attached

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.000	17-4 SS Round Bar 1.000"	.8000 ft (.05 ea)	100-Doosan - 1	M126689 J.172297

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-H1150-R1.000	1	17	0 5.368

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Nut	0.875Inches ± 0.010	0.885 0.865		
2	Nut	0.530Inches ± 0.010	0.540 0.520		
3	Nut	90.000Degrees ± 0.500	90.500 89.500	Angle	/
4	Nut	0.660Inches ± 0.010	0.670 0.650		
5	Nut	0.130Inches ± 0.010	0.140 0.120		
6	Nut	0.580Inches + 0.000 - 0.002	0.580 0.578		
7	Nut	0.590Inches ± 0.010	0.600 0.580		

Plex 7/11/19 9:54 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____		DISPOSITION				DEPARTMENT/PROCESS				Route update only							
Part No. _____		Rework Scrap Use-as-is				Cross tube Small Fab Finishing				Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging							
Date: _____		Sequence #: _____		QTY Affected: _____		MRRB (QSI042)											
Description Work Order Deviation						Disposition											
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors						FAULT CATEGORY											
						Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled			Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function			Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up			Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread		
						Other/Details: _____											
Completed By						Lead hand / Supervisor						QC / QA Coordinator					

1

2

3

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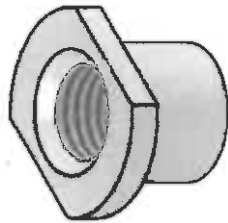
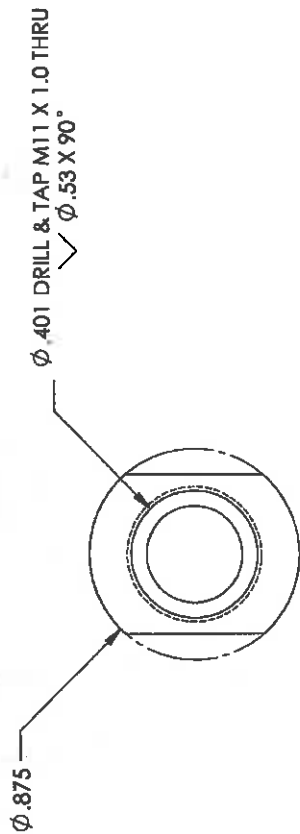
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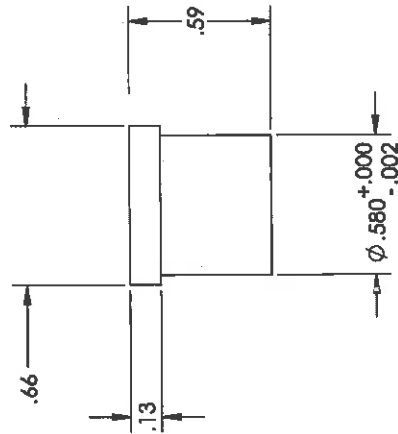
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647.2511



ORIGINAL DATE: 06/06/99		APICAL INDUSTRIES	
APPROVED BY: J. GARDNER		2408 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: P. BRAY		OCEANSIDE, CA, 92056-3512 (760)724-3300	
CONTRACT NO.		SKID SLEEVE	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES 2 PLACE DECIMALS ±.01 ANGLES ±.5°		SIZE: CAGE CODE: 07M26	REV: A
		DWG. NO.: 647.2500	SHEET 2 OF 2
		SCALE: NONE	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044341



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044341
PO Date: 8/26/19
Due Date: 9/4/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2019-08-28

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197604	647.2511	Nut : Various STC's Issue P/O: Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed	-	9/4/19	26 pcs	✓ 0 pcs	26 pcs	\$2.3255/pcs	\$60.46
2	197603	647.2510	Sleeve : Various STC's Issue P/O: Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed	-	9/4/19	17 pcs	✓ 0 pcs	17 pcs	\$2.3255/pcs	\$39.53

Grand Total: \$100.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/28/19 9:10 AM Dart.Guerin.Kimberley


Certificat de Conformité / Certificate of Compliance


0 2 1 8 8 7 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip
021887 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
30-Aug-2019		Karan Singh		POHB044341 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	647.2511 Rev. ✓	647.2511 01-PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	26 ✓	26	DAS 61 9-89	0	0
2	647.2510 Rev. ✓	647.2510 01-PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	17 ✓	17	0	0	0

RECEIVED
 SEP 03 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

 Epaisseur réelle
 Actual Thickness

 Inspecteur Qualité
 Quality Inspector

 Réçu par
 Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.